Work Order Thursday, January	ID 65930 27, 2011 11:27:44 Al	М										Page 1
Revision ID:)3535-13			Accept					Setup	Start Stop		
	/earshoe /27/2011 Start Qty /7/2011 Req'd Qt			1 9011 (BB)	Cust Item Customer:	ID:				СССР	1 12 2 7 1 1 1	
	Process Plan:	" (Date: <u>//-//</u>	/-27tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	ject y	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr											
D3535	Rev B											
	FLOW WAT			0.00				B	.11 <u>~1</u> -	-31		
Waterjet FLOW CNC Waterjet 304 · O(5)		Memo I-Cut as per l Deburr if nec		0.00 g Rev:□Prog Rev:_	□2-		,	Ţ.		,		
	QC2- Inspec	t parts off ma	ichine FAI/FAIB	0.00				J.	> 11 - 1	-31		
QC Quality Control		Memo		0.00								
120	QC8- Inspec	t parts - secoi	nd check	0.00	1							
QC Quality Control		Memo		0.00	1/7/			42)			

Dart Aerospace Lt	d	
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PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		1			
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AR #: Fault Category:	NCR: Ye	es No DQ	A:	Date:	
Disposition:	QA: N/C	Closed:		Date:	
	Disposition:	Disposition: QA: N/C		Disposition: QA: N/C Closed:	AR #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	TE STEP Description of NC Section A		Initial Chief Eng	Action Description S Chief Eng		Section C	Chief Eng	QC Inspector
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Work Order ID 65930

Thursday, January 27, 2011 11:27:44 AM



Page 2

Item ID:

D3535-13

Accept



Setup Start



Revision ID:

Item Name:

Wearshoe

Start Date: 1/27/2011

Required Date: 2/7/2011

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Stop

Sequence ID/ **Work Center ID**

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form

joggle as per Dwg D3535 using Jig DT8158Identify as D3535-13

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

QC

150

QC5- Inspect part completeness to step on W/O

10/ Goly 8

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

Powdercoat Powder Coating

12 Bl 11-02-1

Dart A	erospace	Ltd
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W/O:			WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	;	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C Clo	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 65930

Thursday, January 27, 2011 11:27:44 AM



Page 3

Item ID:

D3535-13

Wearshoe

Accept

Setup Start



Start Date:

Required Date: 2/7/2011

Revision ID:

Item Name:

1/27/2011

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Reject

Qty

Start

Stop



Number Stamp

Reject

Date:_____

SPC (Y/N):

Set Up/

Run Hours

Date:

Code

Tool # Plan

Stop

Insp.

Sequence ID/ **Work Center ID**

160

QC

Operation Description

QC3- Inspect Part Finish

Memo

0.00

11/02/07

Tool ID

Accept

Qty

Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:			WO	RK ORDER CHANGI	ES		_		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		esolution:							
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	k Sect	tion C	Chief Eng	QC inspector
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Picklist Print

Thursday, January 27, 2011 11:27:50 AM

Work Order ID: 65930

Parent Item: D3535-13

Parent Item Name: Wearshoe

Start Date: 1/27/2011

Required Date: 2/7/2011

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	182.9000	0.8505	8.952632	10.3		
											1B(1-1-	31	

304/316 .040 Sheet

Location	Loc Qty	Loc Code	
MAT	182.9		
115953	32.1		
116437	54.8		
116623	96		116673

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W/O:			WO	RK ORDER CHANGE	ES				
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	R	esolution:						Date: _	
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DART AEROSPACE LTD	Work Order:	43930
Description: Wearshoe	Part Number:	D3535-13
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1,891	80		V HB-CR	
2.000	+/-0.010	7.000	7		V	
5.650	+/-0.010	5.666	2		T	
9.150	+/-0.010	9.150	6		T	
14.066	+/-0.010	14.066	>	•	7	
18.983	+/-0.010	18.983	7		1	
23.900	+/-0.010	23,900	ø		+	
27.400	+/-0.010	27,400	8		T	
29.400	+/-0.010	24.400	62		T	
32.900	+/-0.010	33.900	b		7	
Ø0.188	+0.005/-0.001	,190	A		V	
20.00	+/-0.030	20.00	*		7	
14.00	+/-0.030	14.00	>		T	
8.00	+/-0.030	8.00	ل ا		T	
5.00	+/-0.030	5.00	×		T	
0.300	+/-0.010	,301	82		ν	
0.300	+/-0.010	(365)	Ø		V	
0.038	+/-0.010	PEO,	フ		V	

Measured by: \(\mathbb{K}	Audited by:	Prototype Approval:	N/A
Date: (1-1-3)	Date: 11/2//3/	Date:	N/A

Rev	Date	Change	<u> </u>	Revised by∧	Approved
Α	08.04.15	New Issue		KJ/DD TH	X

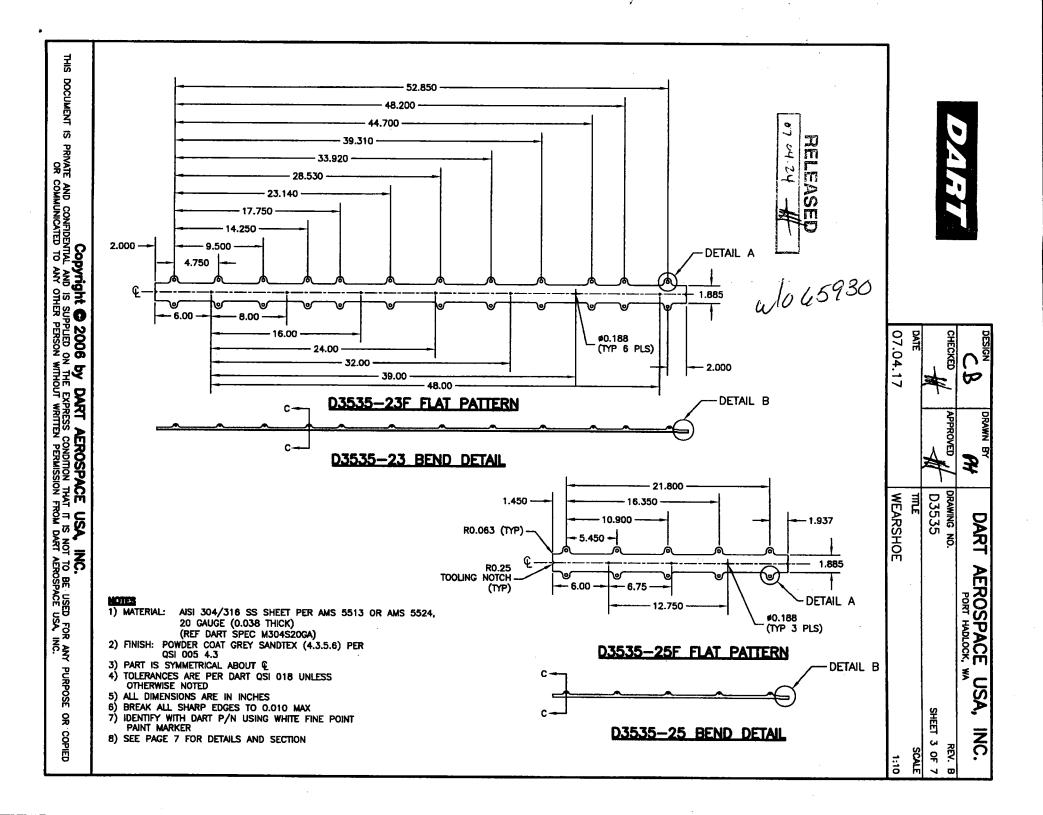
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W/O:			WC	ORK ORDER CHANGES	3				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		Corrective Action Section B		Varification	A	A •	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	

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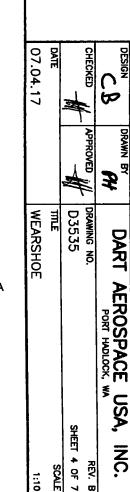
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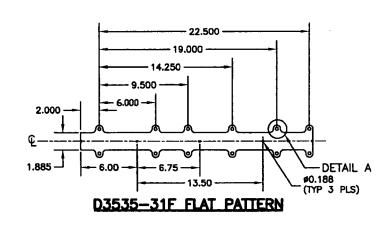


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D3535-31 BEND DETAIL

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-	21.000 —
-	15.250
-	9.500
2.000	-6.000 -
£	
1.885	00.18B
	D3535-33F FLAT PATTERN

D3535-33 BEND DETAIL

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DOCUMENT

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PURPOSE

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COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

- PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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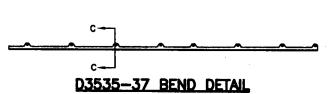
23.250 19.750 17.750 14.250 9.500 4.750 2.000 #0.188 (TYP 2 PLS) 1.885 - DETAIL A

D3535-35F FLAT PATTERN



30.750
27.250
22.500
17.750
14.250
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21.00
D3535-37F FLAT PATTERN (TYP 4 PLS)

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
 - 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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DOCUMENT IS

PURPOSE

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CHECKED B

07.04.17

WEARSHOE

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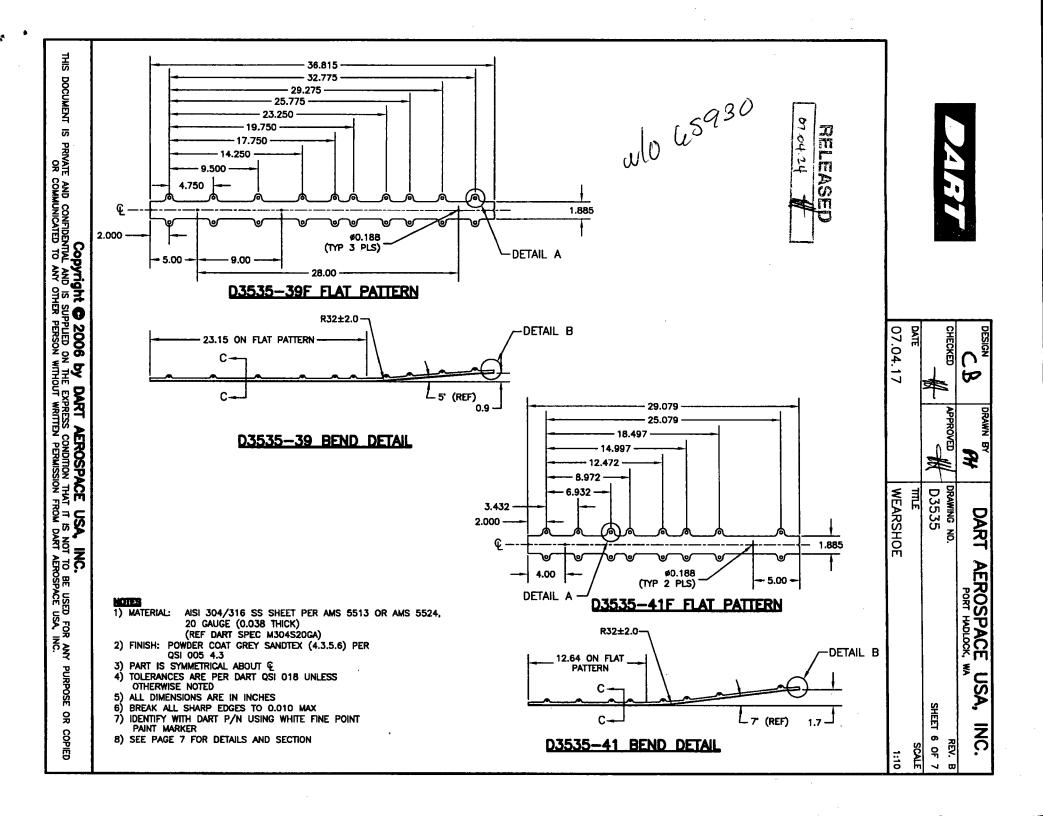
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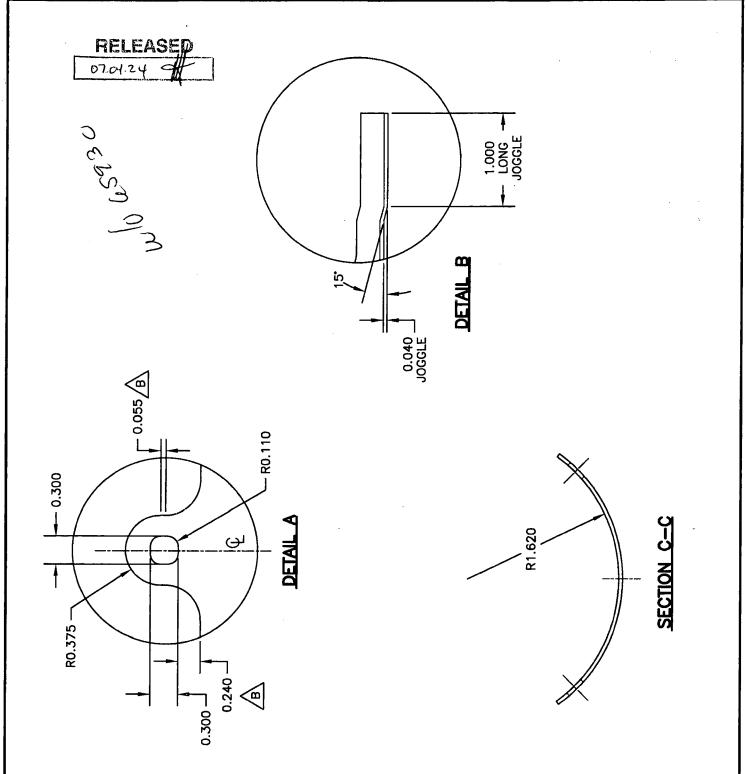
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DATE	STEP	Description of NC	Corrective Action Sec		tion B		cation	Approval	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Dat		tion C	Chief Eng	QC inspector



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		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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